120

Quality Control

QC5- Inspect part completeness to step on W/O

3-Deburr as required

Memo

0.00

0.00

DQA: ____ Date: ___

NCR: Y	es /	No				WORK ORDER NON-O	CONFO	RMANCE / U	PDATE			
										QA Closed:	Date	<u>:</u>
Work Orde	r:					DISPOSITION			AGAINST DE	EPARTMENT,	/PROCESS	
Part No.				Rework Scrap		Skid-tube Machining		Water Jet d. Eng. Coor.	Engineering Quality			
NCR No.				Use-as-is Thermoforming Finishing Work Order Update Large Fab Composite		·						
Root					Descri	ption of work order update	Initia	7	Action	Sign &		
Cause	Da	te St	ер	Qty		or Non-conformance	Chief E	ng Des	scription	Date	Verification	QC Inspector
oc/Data												
quip/Tooling			Ì	ı								
perator		:										
/laterial		l		İ								
etup										'		
Other	į											·
rocess												
upplier				1						'		
raining		- [
Inapproved										<u> </u>		
						F.	AULT CA	TEGORY				
Landir	ng Gear					General			·	_	_	
	Bend	ing				Bend	Grai	n	_	Ovalized	L	Pressure/Forced
	Cent	e Not Co	oncent	ric to O	/S	BOM/Route	Hard	ware		Over/Under	tolerance	Temperature/Cure
[Crac	(S		•		Broken/Damaged	Insp	ection Incomplete	L	Part Incorre	ct _	Weld
	Crus	ned/Crim	ped			Burrs	Instr	uctions Incomplete	e/Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled
	Cuffs					Contamination	Mai	ntenance		Part Moved		•
	Heat	Treat				Countersink	Misla	beled	L	Positioned V	Vrong	
- 1	Inspe	ction Str	ip in T	ube		Cut Too Short	Misr	ead		Power Loss/	Surge	Other
	Ripp	es in Ber	nd			Drill Holes	Offse	et				
ľ	Torq	ue Wave	s in Ex	trusion		Drawing	Out	of Calibration				
	Turn	ng Seque	ence			Finish	Out	of Sequence				
	Wav	e/Twist in	n Tube	•		Folio	Outs	ide Dimensions				

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

March-28-13	10:47:48 AM		
Item ID:	D2037-101		Acc
Revision ID:			
Item Name:	Arm		
Start Date:	3/27/13	Start Qty: 4.00	*4*
Required Dat	e: 3/27/13	Req'd Qty: 4.00	*4*

Cust Item ID:

N900040100

Stop *NS2*

Setup Start

Page 2

Customer:

					Kun	Start	*/////
Approvals:	Process Plan:	Date:	Tooling:	Date:			
						Stop	
	QC:	Date:	SPC (Y/N):	Date:		•	*NP?
							1411

Sequence ID/	Operation	Set Up/	Tool ID	Tool # Plan	Accept	Reject	Reject	Insp.
Work Center ID	Description /	Run Hours		Code	Qty	Qty	Number	Stamp .
130	Identify as per dwg & Stock Location:	0.00			γ			
130					(4)	A-1	13-5-13	
Packaging	Memo	0.00			<u> </u>			

140

Packaging

QC21- Final Inspection - Work Order Release

0.00

140

QC Quality Control

Memo

0.00

MK 13-5-43

										DQA:	Date	:	
NCR: Ye	es / No				WORK ORDER NON-O	CON	IFORI	MANCE / UPD	ATE	QA Closed:	Date	::	
Work Order	·:				DISPOSITION		AGAINST DEPARTMENT/PROCESS						
Part No				Scrap Machin Use-as-is Thermoform		Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	4	Water Jet d. Eng. Coor. e/Packaging Supplier	Engineering Quality Other			
Root Cause	Date	Step	Qty		ption of work order update or Non-conformance		nitial ief Eng	Actio Descrip		Sign & Date	Verification	QC Inspector	
quip/Tooling quip/Tooling Operator Material etup Other Process supplier Training													
						AUL	CATE	GORY	· · · · · · · · · · · · · · · · · · ·				
Landin	Bending Centre No Cracks Crushed/ Cuffs Heat Trea Inspectio Ripples in Torque W	Crimped at n Strip in n Bend Vaves in E	Tube		General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing		Instruct Mainte Mislabe Misread Offset Out of O	on Incomplete ions Incomplete/Ur enance eled f	nclear	Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned W Power Loss/	ssing /rong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other	
-	Turning S	•		-	Finish	-		Sequence					
1	Wave/Twist in Tube			Folio	Outside Dimensions								

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Picklist Print

March-28-13 10:47:48 AM

Work Order ID:

98974

Parent Item:

D2037-101

Parent Item Name:

Arm

01 Start Date

122468 124768

125068

Start Date: 3/27/13

Required Date: 3/27/13

Page 1

Start Qty: 4.00

Required Qty: 4.00

Comments:

IPP Rev:A New Issue 05-11-01 JLM

IPP Rev:B 08-07-29 revD as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TR0.750W.049		Purchased	No			110	f	537.2067	3.916	16.488421			
304 RD Tube .750 x .049W	<i>i</i>			Location		Loc Qty	Le	oc Code				56	136056
				MAT017		537.2066825							
				1223	12	22.37							

0.0000325

314.83665

200

16.5

										DQA:	Date:	:	
NCR:	es / f	lo			WORK ORDER NON-C	COI	VFORM	MANCE / UP	DATE	QA Closed:	Date:		
					I.					QA Closed.	Date		
Work Orde	ar.				DISPOSITION			AGAINST DEPARTMENT/PROCESS					
WOIK OIGE					Rework	1		Skid-tube	Crosstube]	Water Jet	Engineering	
Part N	lα				Scrap	1		Machining	Small Fab	Pro	d. Eng. Coor.	Quality	
					Use-as-is	1		noforming	Finishing		re/Packaging	Other	
NCR N	No.				Work Order Update	1 1		Large Fab	Composite	1	Supplier	1 -	
								~ L					
Root	į			Descri	ption of work order update		nitial	Ac	tion	Sign &			
Cause	Da	e Step	Qty	,	or Non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector	
Doc/Data													
Equip/Tooling													
Operator		l											
Material			`				•						
Setup													
Other			1										
Process													
Supplier													
Training		ļ											
Unapproved									·	<u> </u>			
		 			F	AUL	T CATE	GORY					
Landi	ng Gear			_	General	_				1	-	7	
	Bend	_			Bend	_	Grain		<u> </u>	Ovalized	<u> </u>	Pressure/Forced	
	Centr	e Not Conc	entric to	o/s	BOM/Route	\Box	Hardwa			Over/Under	-	Temperature/Cure	
	Crack				Broken/Damaged	L	1	on Incomplete	<u> </u>	Part Incorre	-	Weld	
		ed/Crimpe	d	<u> </u>	Burrs	\vdash	1	ions Incomplete/	Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled	
	Cuffs	*			Contamination	L	Mainte	nance		Part Moved			
,	Heat	Treat			Countersink		Mislabe	led		Positioned V	Vrong	7	
	Inspe	ction Strip i	n Tube		Cut Too Short	İ	Misread	!		Power Loss/	Surge	Other	

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drill Holes

Drawing

Finish Folio D2037-101 ARM

Coar

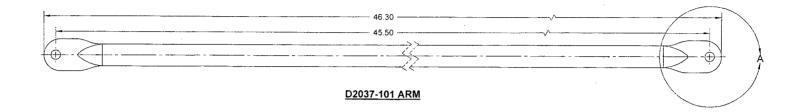
INCORPORATED C1.C2 & C3. REDRAWN TO SOLIDWORKS FORMAT WITH CURRENT STANDARDS. ORIGINAL "SOUARE BOD" CONFIGURATION DELETED (SEE REV. C FOR FURTHER DETAILS). SHEET 2 DETAIL A NOW INDICATED AS 2 PL. REASON FOR CHANGE: QC/PRODUCTION REQUEST. AJS 08.05.08 REDRAWN, 0.386 WAS 0.375. RF 99.06.07 В -103 DELETED JB 93 04.20 NEW ISSUE JB 91.10.22 REV. DESCRIPTION DATE ВУ

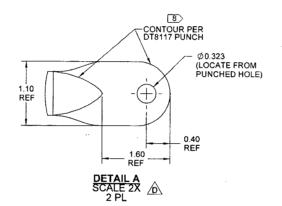
DESIGN	1B	DART AEROSPACE LTD					
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA					
CHECKED	5	DRAWING NO. REV	V. D				
MFG. APPR.	7.78	D2037 SHEET 1	OF 2				
APPROVED	With.	TITLE SC	ALE				
DE APPR.	7	∏ ARM ;	NTS				
DATE 08	05 08	COPYRIGHT @ 1991 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND COMPOSITING AND IS SUPPLIED ON THE COPYESS CONDITION THAT IS	r is				

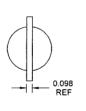
NOTES:
1) MATÉRIAL: AISI 304/316, STAINLESS STEEL ROUND TUBE, Ø0.750 x 0.049 WALL REF. DART SPEC M304TR0.750W.049
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NIA

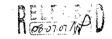
6) IDENTIFICATION: N/A

7) WEIGHT: 1.50 lbs 8) FOR FURTHER INFO SEE DRAWING D2638.









DESIGN JB		DART AEROSPACE LTD				
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA				
CHECKED	5.	DRAWING NO.	REV. D			
MFG. APPR.		D2037	SHEET 2 OF:			
APPROVED	7/1/2	TITLE	SCALE			
DE APPR.	#	∏ARM	NTS			
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